



Dart Aerospace Ltd.
1270 Aberdeen St
Hawkesbury, ON
K6A 1K7
Canada

Tel (613) 632-5200
Fax 613 632-5246

RB6872882-6
Job Sheet 183465



Part No: RB6872882-6

Job Qty: 8 ea

Part Name: Jack Screw



Part Weight: 0 lbs

Status: Scheduled

Priority: Medium

Job Created: 9/18/18

Job Tracking No:

Due Date: 10/4/18

Created By: Logan David

Type: SOLD

Description:

Note: DWG RB6872882 Rev. 5 IPP Rev. A 18.09.17 New issue DP Verify DD

Ship Via:

Bill of Materials

Job Routing

Op No	Operation	Qty	Start Date	Due Date	Standard		Workcenter/Supplier		Sign-off
					Setup Hrs	Run Hrs	Workcenter / Supplier	Lead Time	
90	Start up Operation	6 Ea	10/4/18	10/4/18	0.00	0.00	Start Up Machining-3		JB 18.10.22
110	CNC Lathe	6 pcs	10/4/18	10/4/18	0.00	0.75	MORI SL-154		JB 18.10.22
120	QC	6 pcs	10/4/18	10/4/18	0.00	0.00	QC2 Machining-4		JB 18.10.22
130	QC	6 pcs	10/4/18	10/4/18	0.00	0.00	QC8 Machining-4		manl 18/10/25
135	Outsource	6 pcs	10/4/18	10/4/18	0.00	0.00	Outsource1		CC 18.1.11
140	Outsource	6 pcs	10/4/18	10/4/18	0.00	0.00	Outsource12		NR -> Atlantic doing both
150	Packaging	6 pcs	10/4/18	10/4/18	0.00	0.00	Packaging2		NOV 1 0 2018
160	QC	6 pcs	10/4/18	10/4/18	0.00	0.00	QC6		NOV 1 2 2018
210	Packaging	6 pcs	10/4/18	10/4/18	0.00	0.00	Packaging3-1		NOV 1 2 2018
220	QC21-SA	6 Ea	10/4/18	10/4/18	0.00	0.00	QC21		NOV 1 2 2018

Part Op 110 - 1-Machine as per DWG. FC361 FOLIO REV: _____ DWG REV: _____ 2-Deburr
Descriptions: 135 - 1-Issue P/O to Metcore ; P/O 04158 RC 36-40 2-Bead blast 3- Certificate of Conformity is required
NOTE DROP SHIP TO FINISHER Metcore to ship directly to Groupe Altech***
140 - BLACK OXIDE (RED BARN) -Issue P/O to Groupe Altech; PO _____ -Black oxide finish, MIL-C-13924C
Class 1 -Certificate of Conformity is required

Job BOM

Part / Item	Component Name	Quantity	Operation	Container
M4140H-R1.250	4140 Round Bar 1.250	3.2460 ft (.541 ea)	90-Start up Operation	

Job Allocations

Operation	Component Part	Required	Inventory	Allocated
90-Start up Operation	M4140H-R1.250	3	22	0



Container No: S120243



Part: RB6872882-6

Job No: 183465

Serial No/Batch: S120243

Revision: 5

Inspector:

Exp Date:

Instructions:

Date: 10/22/18

Dart Aerospace Ltd.
1270 Aberdeen Street
Hawkesbury, ON K6A 1K7
CANADA
TEL: 1 613 632-5200
Email: sales@dartaero.com
www.dartaerospace.com

Part Specifications

Specifications could not be found.

Plex 10/21/18 8:01 AM dart.auclair.guillaume

Atlantic

200
53
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REVISIONS				
REV	ECR	DESCRIPTION	DATE	INITIAL
4	15-0046	CH'D DIMS WAS Ø.500 IS Ø.4995-.5000, WAS Ø.187 IS Ø.1871-.1874 THRU.	2/26/2015	PMW
5	17-0110	-6 CH' DIMS WAS Ø.1874/.1871 THRU P.F. -8 IS Ø.1874/.1871 THRU ALL-(P.F.-8), WAS Ø.5000/.4995 S.F. -9B IS Ø.5000/.4995 (S.F. -9B). WAS .620 IS .62. DELETED DIM .310. ADDED DIM .310 +.010/-.000. ADDED FINISH SPEC QMSI-6.2.2, B.O. REV D.	5/8/2017	RJC

Ø 1.20



5/8 - 11 UNC - 2A

Ø.1874 THRU ALL
Ø.1871 (P.F.-8)

Ø.5000
Ø.4995
(S.F.-9B)

.06 X 45°

.310
.300

.310 +.010
-.000

45°

2X .03 X 45°

Ø.635

.25

6.50



TITLE
PULLER, TURBINE FRONT BEARING

DWG NO. RB6872882-6 REV 5

MAT'L 4140/4142	UNLESS OTHERWISE SPECIFIED DIMENSIONS ARE IN INCHES
HEAT 36-40	.XXX ± .005 FRACTIONS ± 1/8
TREAT	.XX ± .01 ANGLES ± 5°
FINISH BLACK OXIDE	.X ± .1 SURFACES = 125/
SPEC QMSI-6.2.2, B.O. REV D	1. BREAK ALL SHARP EDGES .015 X 45° OR .015R
DRAWN BY: COLE	2. DIMENSIONAL LIMITS APPLY AFTER PLATING
CHECKED: DD 05/09/2017	3. INTERPRET DIM AND TOL PER ASME Y14.5M-2009
OPPS APPR: AA 05/10/2017	USED ON MODEL
QA APPR: JL 05/24/2017	ALLISON 250 SERIES
APPROVED: JAG 06/02/2017	
SCALE 1:2	DATE 5/18/2007
	SHEET 6 OF 13

(-6)

JACK SCREW



Dart Aerospace Ltd.
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Canada

Tel (613) 632-5200

PURCHASE ORDER PO041558

Supplier: ATL002-VC
Atlantic Heat Treat 2001
401 Frankcom
Ajax
ON
L1S R14 Canada
Phone: 866 257 6395

PO No: PO041558
PO Date: 11/1/18
Due Date: 11/8/18
**Purchase Order
Revision:**
Revision Date:
Ship-To Contact: Tsimiklis, ChrisoulaPhone:

Ship To: 1270 Aberdeen Street
Hawkesbury
ON
K6A 1K7 Canada
Phone: 613-632-5200

Pymt Terms: Net 30
Freight Terms:
Special Comments:

Items

Line Item	Job	Part	Description	Status	Account	Due Date	Order Quantity	Received Quantity	Balance	Unit Price (CAD)	Extended Price
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PURCHASE ORDER **PO041558**

Items

Line Item	Job	Part	Description	Status	Account	Due Date	Order Quantity	Received Quantity	Balance	Unit Price (CAD)	Extended Price
1	182151	RBST2812-P-1	1-Issue P/O to Atlantic; P/O RC55-60 2-Bead blast ***NOTE*** ensure abrasive blasting does not damage the critical surfaces 3- Certificate of Conformity is required -***Polish race surface as per note 3 prior to black oxide.*** -Black oxide finish, MIL-C-13924C Class 1 -Apply thin layer of oil/CPC per MIL-PRF-16173 Grade 3 Class 1 or MIL-c-81309 Type III Or MILL-C23411A or MIL-PRF-81309 and wipe off excess. -Material type; O1 -Certificate of Conformity is required ***NOTE*** ensure abrasive blasting does not damage the critical surfaces 3- Certificate of Conformity is required	Firmed	-	11/5/18	10 pcs	0 pcs	10 pcs	\$21.45/pcs	\$214.50

10 x NOV 10 2018

DAS
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9-89

Line Item Note **need asap**



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PURCHASE ORDER **PO041558**

Items											
Line Item	Job	Part	Description	Status	Account	Due Date	Order Quantity	Received Quantity	Balance	Unit Price (CAD)	Extended Price
2	183465	RB6872882-6	1--Issue P/O to Atlantic; P/O RC 36-40 2-Bead blast 3- Certificate of Conformity is required BLACK OXIDE (RED BARN) -Black oxide finish, MIL-C-13924C Class 1 -Certificate of Conformity is required	Firmed	-	11/5/18	7 pcs	0 pcs	7 pcs	\$30.642857/pcs	\$214.50
7 X NOV 10 2018											
Line Item Note * need asap *										Grand Total:	\$429.00

Order Notes

Procurement Quality Clauses
A005 right of entry
A012 chemical and physical test report
A016 personnel qualification
A017 raw material identification (as applicable)

A022 Apical Processing
A024 process certifications
A026 certification of material conformance

A041 quality management system
A042 dart notification by supplier
A043 retension of quality documents

A048 counterfeit parts avoidance, detection, mitigation and disposition program

A049 supplier awareness

Terms & Condition of Purchasing(Suppliers) and Procurement Quality Clauses are an integral part of our AS9100 requirements. To learn in detail, please visit www.dartaerospace.com for further explanation.

Plex 11/6/18 3:34 PM dart.tsimiklis.chrisoula

Atlantic Heat Treating (2001) Ltd

Order No.: 160058

Ship Date: 5/11/2018

Shipping Ticket

Sold To: 1448
DART AEROSPACE LTD.
1270 ABERDEEN ST

HAWKESBURY ON K6A 1K7

Ship To: 157178
DART AEROSPACE LTD.
1270 ABERDEEN ST

HAWKESBURY ON K6A 1K7

Page 1 of 1

Purchase Order Number	Packing List No	Customer Job No	Route	Carrier
PO041558 ✓				

Quantity	Part No. / Part Name / Part Description	Pounds
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✓ 7PCS MATERIAL 4140

SAND BLAST AND HEAT TREAT TO 36-40RC ✓

BLACK OXIDE, C OF C, PRT# RB6872882-6, JOB# 183465 ✓

Container Type	# Of Containers	Cust Cont Id	Container Type	# Of Containers	Cust Cont Id
BOX	1				

NOTICE: OUR LIABILITY IS LIMITED TO OUR INVOICE CHARGES ONLY

Shipped Complete

Quantity Shipped:

7

Pounds Shipped:

4.00

Bo ^{sd}

40 Rc

11-6-18

Order No.: 160058

Shipped Complete

Quantity Shipped:

7.00

Received By:

Date:

Pounds Shipped:

4.00

Sold To: DART AEROSPACE LTD.

Shipped ON: 11/05/2018

Shipping Ticket

DATE OF DEPARTURE
10/10/10

DATE OF ARRIVAL
10/10/10

NAME OF SHIPPER
M. S. S. S.

NAME OF DESTINATION
M. S. S. S.

NAME OF VESSEL
M. S. S. S.

NAME OF CARRIER
M. S. S. S.

NAME OF SHIPPER
M. S. S. S.

NAME OF DESTINATION
M. S. S. S.

NAME OF VESSEL
M. S. S. S.

NAME OF CARRIER
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M. S. S. S.

NAME OF DESTINATION
M. S. S. S.

NAME OF VESSEL
M. S. S. S.

NAME OF CARRIER
M. S. S. S.

Certification

Date: 11/05/2018

Entry Date: 11/05/2018

Page: 1 of 1

To:DART AEROSPACE LTD.
1270 ABERDEEN ST

Purchase Order No.: PO041558

Packing List No.:

HAWKESBURY ON K6A 1K7

Material: 4140

We are pleased to provide you with the following Certificate of Compliance.

Quantity	Part Number / Part Name / Part Description	Pounds
7	7PCS MATERIAL 4140 SAND BLAST AND HEAT TREAT TO 36-40RC BLACK OXIDE, C OF C, PRT# RB6872882-6, JOB# 183465	4

Insp. Type	Scale	Minimum	Maximum	Number	Other
Customer Requirements:					

Harden rockwell

Results:

Harden ROCKWE 36. 40. 40. TESTED AS PER SAMPLING PLAN

HEAT TREATED TO 40 RC AS PER CUSTOMER REQUEST

BLACK OXIDE AS PER CUSTOMER REQUEST

STATEMENT OF LIMITED LIABILITY (PLEASE READ CAREFULLY). ALL WORK IS ACCEPTED SUBJECT TO THE FOLLOWING CONDITIONS. It is recognized that even after employing all the scientific methods known to us, hazards still remain in metal treating. THEREFORE, OUR LIABILITY SHALL NOT EXCEED TWICE THE AMOUNT OF OUR CHARGES FOR THE WORK DONE ON ANY MATERIAL (FIRST TO REIMBURSE FOR THE CHARGES AND SECOND TO COMPENSATE IN THE AMOUNT OF THE CHARGES), EXCEPT BY WRITTEN AGREEMENT SIGNED BY THE METAL TREATER. THE CUSTOMER, BY CONTRACTING FOR METAL TREATMENT, AGREES TO ACCEPT THE LIMITS OF LIABILITY AS EXPRESSED IN THIS STATEMENT TO THE EXCLUSION OF ANY AND ALL PROVISIONS AS TO LIABILITY ON THE CUSTOMER'S OWN INVOICES, PURCHASE ORDERS OR OTHER DOCUMENTS. IF THE CUSTOMER DESIRES HIS OWN PROVISIONS AS TO LIABILITY TO REMAIN IN FORCE AND EFFECT, THIS MUST BE AGREED TO IN WRITING, SIGNED BY AN OFFICER OF THE TREATER, IN SUCH EVENT, A DIFFERENT CHARGE FOR OUR SERVICES REFLECTING THE HIGHER RISK TO TREATER, SHALL BE DETERMINED BY THE TREATER AND CUSTOMER. THE TREATER MAKES NO EXPRESS OR IMPLIED WARRANTIES AND SPECIFICALLY DISCLAIMS ANY IMPLIED WARRANTY OF THE FITNESS FOR A PARTICULAR PURPOSE OR MERCHANTABILITY, AS TO THE PERFORMANCE OF CAPABILITIES OF THE MATERIAL AS HEAT TREATED, OR THE HEAT TREATMENT. THE FOREMENTIONED LIMITATION OF LIABILITY STATED ABOVE IS SPECIFICALLY IN LIEU OF ANY EXPRESS OR IMPLIED WARRANTY, INCLUDING ANY IMPLIED WARRANTY OF MERCHANTABILITY OR FITNESS, AND OF ANY OTHER SUCH OBLIGATION ON THE PART OF THE TREATER. No claim for shortage in weight or count will be entertained unless presented within five (5) working days after receipt of materials by customer. No claim will be allowed for shrinkage, expansion, deformity, or rupture of material in treating or straightening, except by prior written agreement, as above, nor in any case for rupture caused by or occurring during subsequent grinding. Whenever we are given material with detailed instructions as to treatment, our responsibility shall end with the carrying out of those instructions. Failure by a customer to indicate plainly and correctly the kind of material (i.e., proper alloy designation) to be treated, shall cause an extra charge to be made to cover any additional expense incurred as a result thereof, but shall not change the limitation of liability stated above. Customer agrees there will be no liability on the treater in contract for any special, indirect or consequential damages arising whatsoever, including but not limited to personal injury, property damage, loss of profits, loss of production, recall or any other losses, expenses or liabilities allegedly occasioned by the work performed on the part of the treater. It shall be the duty of the customer to inspect the merchandise immediately upon its return, and in any event claims must be reported prior to the time that any further processing, assembling or any other work undertaken. OUR LIABILITY TO OUR CUSTOMERS SHALL CEASE ONCE ANY FURTHER PROCESSING, ASSEMBLING OR ANY OTHER WORK HAS BEEN UNDERTAKEN ON SAID MATERIAL. No agent or representative is authorized to alter the above conditions, except by writing duly signed by an officer of treater.


KEAN SHEPHERD
QUALITY CONTROL
ATLANTIC HEAT TREATING 2001 LTD

68-9
89
DAS

Order No. 10055

Date 10/25/50

City Jan 10/25/50

Page 1 of 1

Subject: (See Page 10055)

Continuation

Purchase Order No. 10055

Issued to

Amount \$100

Page

RECEIVED PER BANK OF AMERICA

NOV 1 1950

AT ANY HEAT TREATING CO.

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